

Date: Wednesday, 3/21/2007 3:40:54 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP SPACER	
Job Number	: 31407C				
Estimate Number	: 10354				
P.O. Number	: N/A		Part Number	: D2322	
This Issue	: 3/21/2007 S.O. No. : N/A		Drawing Number	: D2322 REV C	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: C	
Previous Run	: 30813C		Material	: N/A	
Written By			Due Date	: 4/10/2007 Qty: 20 Um: Each	
Checked & Approved By					
Comment	: Est Rev:A New Issue 05-11-07 JLM Est Rev:B Now on Waterjet 06-07-03 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet
	Comment: Qty.: 0.2132 sf(s)/Unit Total : 4.2630 sf(s) Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick (M2024T3S.040)	
	Identify as D2322 Batch: M104025	ml 07 06 16
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D2322 Dwg Rev: C Prog Rev: C	ml 07 06 16
	2-Deburr if necessary	mf 07-06-25
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	ml 07 06 16
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	Er 07/06/18
5.0	BRAKE NC	NC BRAKE
	Comment: NC BRAKE Form as per Dwg D2322	S3 07/06/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/07/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



(counted)

Comment: INSPECT WORK TO CURRENT STEP

En 07/06/29

(72)

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Fd 07/06/29 (20)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

En 07/07/03 (20)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Ep 07/07/03 (20)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

En 07/07/03

Job Completion:



10/07/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31407C
Description: Step Spacer	Part Number:	D2322
Inspection Dwg: D2322	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	M. M.
Date:	7/16/16

Audited by:	✓
Date:	07/06/18

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue P/O D2582	KJ/JLM <i>[initials]</i>	<i>[initials]</i>



DESIGN BW		DRAWN BY <i>CD</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. C
CHECKED <i>KE</i>	APPROVED <i>MM</i>	DRAWING NO. D2322	SHEET 1 OF 1	SCALE 1:2	
DATE 98.09.29	TITLE STEP SPACER				
A	94.10.14	NEW ISSUE			
C	98.09.29	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER NCR 001			

RELEASED

UNDER REVIEW

~~DESIGN OK, BUT CHECK WITH
DIS MANUFACTURE~~

0.128 (TYP 12 PLACES)

KE 99.05.06
R 0.125
(TYP 4 PLACES)

GRAIN DIRECTION

FLAT LAYOUT

Technical drawing of a U-shaped bracket. The width of the base is 3.400. The height of the vertical leg is 0.62. The thickness of the leg is 0.125. The top horizontal section is labeled "UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 31401C". Above the drawing, there is a note: "SHOP COPY RETURN TO ENGINEERING 6.520 6.270".

MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED